

Work Order ID 128783

128783

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January-27-15 7:09:59 AM

Item ID: D3602-1

Revision ID:

Item Name: Angle

Start Date: 1/27/15 Start Qty: 10.00

Required Date: 1/30/15 Req'd Qty: 10.00

Reference:

Accept
SCAP

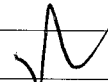
N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3602	Rev B								

100

100

Waterjet

FLOW CNC Waterjet

304.040-AP

Plastic wrapped.

FLOW WATER JET

Memo

USE STAINLESS WITH PLASTIC WRAP

1-Cut as per Dwg D3602

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.00

10 0 Jm 15-2-2

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

10 0 Jm 15-2-2

SCRAP

Work Order ID 128783***128783***

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January-27-15 7:09:59 AM

Item ID: D3602-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle
Start Date: 1/27/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Form as per Dwg D3602								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 03 2015

DQA:

Date: 15/05/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/04/14

Work Order update only ☐

Work Order: <u>128783</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D-3602-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. <u>15-4812</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	15-02-07	100	10	Part should be outsource	6/24/15	Scrap + destroy	DAG 38 9-89		
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup				P.C. update Bom/Route			15-02-06	DAS 9 9-89	15-02-17
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☒ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128783***128783***

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Item ID: D3602-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle
Start Date: 1/27/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

~~SCRAP~~
4/15-2-12

Picklist Print

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Page 1

Work Order ID: 128783

128783

Parent Item: D3602-1

D3602-1

Parent Item Name: Angle

Start Date: 1/27/15

Required Date: 1/30/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-27 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA4P

Purchased

No

100

sf

4.3340

0.585

1

M304S20GA4P

(2)

Jm15-2-2

304/316 Sheet .040

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Location

Loc Qty

Loc Code

MAT020

4.334

m129146

4.334

129146

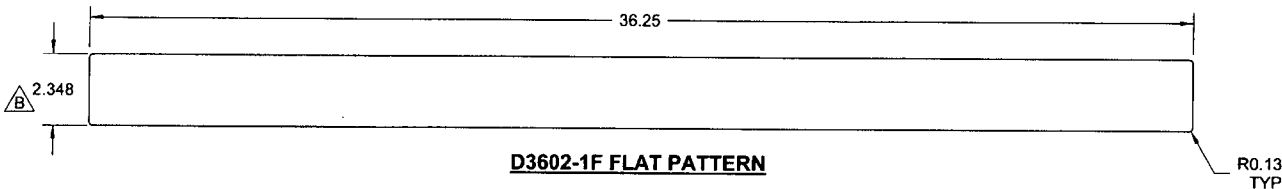
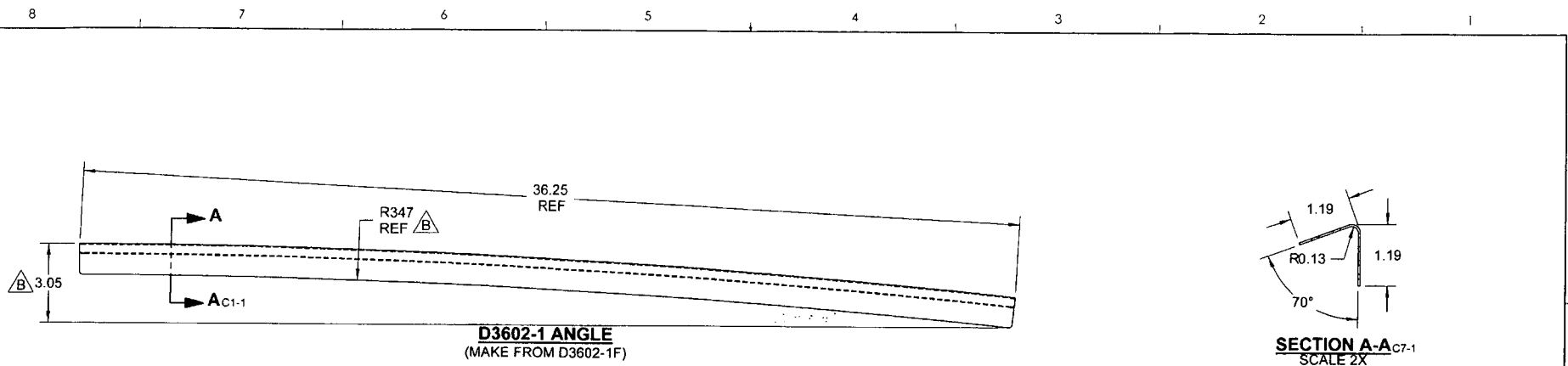
128783

☒ First Article ☐ Prototype

DAC
38
9-89
0000

~~FEB 03 2015~~

ed by	App
	



RELEASED
6/23/11 MB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		
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